

Work Order ID 68673

Tuesday, April 19, 2011 3:58:06 PM



Page 1

Item ID: D2438

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 4/19/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

M

Date: 4/19/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2438	Rev C								

100 PURCHASING 0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D2438

prog rev: *E*

dwg rev: *E*

304.063

1B11-4-20



110 QC2- Inspect parts off machine FAI/FAIB 0.00



QC

Memo

0.00

Quality Control

Ensure Material Release Note is attached

1B11-4-20

120 QC8- Inspect parts - second check 0.00



QC

Memo

0.00

Quality Control

(6.786" center to center)

Subtotal 21

counts



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00				(81)			
Small Fab	Memo	0.00							
Small Fab	1- Use DT9713 clamp holder to hold clamp in place when forming 2- Bend as per dwg usind DT9709			SB 11/16/25					
140 QC	QC5- Inspect part completeness to step on W/O	0.00				count			
Quality Control	Memo	0.00		Subul26		(81)			
						QSPULS			
150 Packaging	Identify as per dwg & Stock Location: 450	0.00							
Packaging	Memo	0.00							
							11/14/26	87	count

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Required Date: 4/25/2011 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/27
mf

11-04-26

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 19, 2011 3:58:15 PM

Page 1

Work Order ID: 68673



Parent Item: D2438



Parent Item Name: Clamp



Start Date: 4/19/2011

Required Date: 4/25/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: E 05.06.28 Bending removed KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	190.0000	0.04	2.526316	3.5		
											1314-25		

304/316 Sheet.063

Location

Loc Qty

Loc Code

MAT020

190

117275,

190

117275



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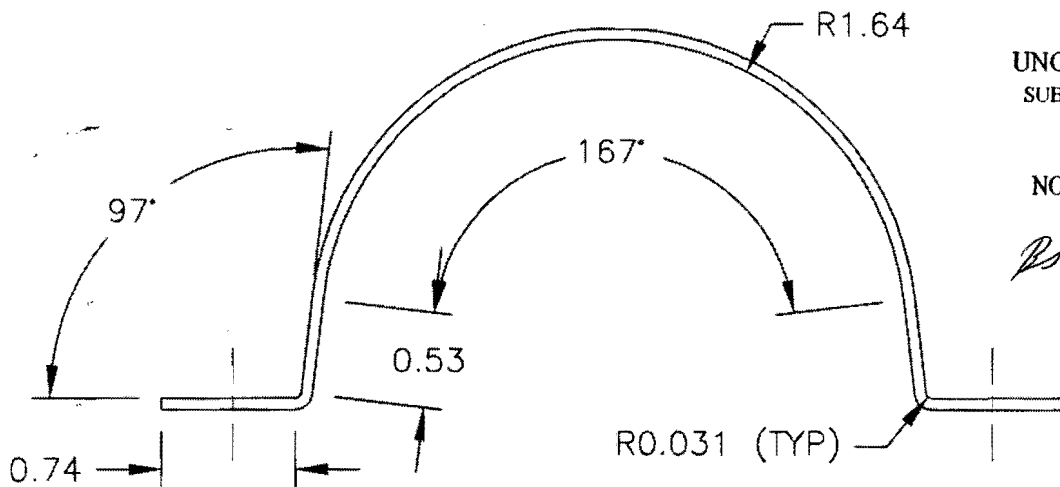
NOTE: Date & initial all entries

DART



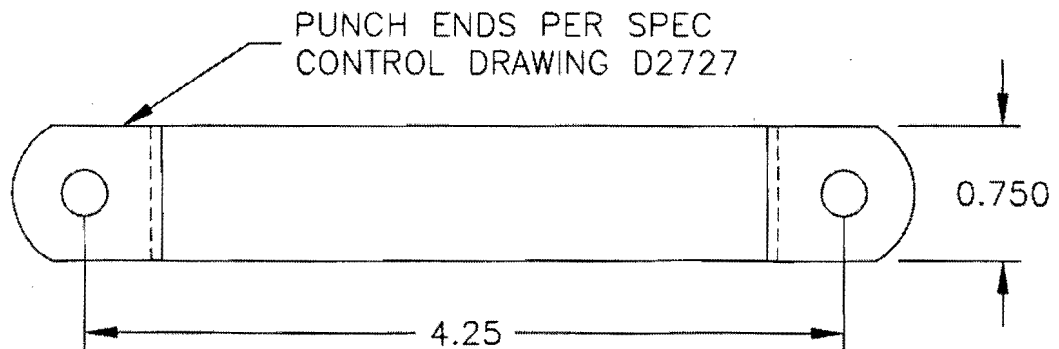
DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>WJ</i>	APPROVED <i>WJ</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
48.06.17 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48673

28110419



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK
MINIMUM REQUIREMENT IS ANNEALED CONDITION

00.06.06
CP 00.06.07

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